

Date: Monday, 12/05/2008 10:01:29 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HELI UTILITY BASKET LH/RH 350/355
Job Number :	39190		
Estimate Number :	10208		
P.O. Number :		Part Number :	D350607043
This Issue :	12/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D350-607 REV F P7-9
First Issue :	1/1	Project Number :	N/A
Previous Run :	39132	Drawing Revision :	F
Written By :		Material :	
Checked & Approved By :	<u>JLD 08.5.12</u>	Due Date :	15/06/2008
Comment :	Est Rev:E as Per DSI9318 06-01-24 JLM Est Rev:F ECN1068 07-12-21 DD verified by:	Qty:	1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 Photocopy bluefile & type labels per PPPD350-607-043 CHG004

08/05/27 JLD
08.5.13

2.0	39190A	BASKET LID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component BASKET LID ASSEMBLY
 D2989-041 B 39190A

08/05/26 @

3.0	39190B	BASKET LID ASSEMBLY
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Comment: Sub-Component BASKET LID ASSEMBLY
 D2989-043 B 39190B

08/05/26 @

4.0	39190C	BASKET BASE ASSEMBLY (350)
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Comment: Sub-Component BASKET BASE ASSEMBLY (350)
 D2221 B 39190C

08/05/26 @

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick: Assembly Kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:01:29 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39190

Part Number: D350607043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	NAS1515H4	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 NAS1515H4 WASHER M106919

JS 08/05/22 (X)

7.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

5 D2022-101 Spacer 33985

JS 08/05/22 (X)

8.0	D2258200	Placard 200lb
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2258-200 Label 36848

JS 08/05/22 (X)

9.0	D2332041	Lid Prop Assembly 6.69" long
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y 38597

JS 08/05/22 (X)

10.0	D2530	Handle Weldment
------	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment ~~38597~~ B37853

JS 08/05/22 (X)

11.0	D2535	Spring
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring 37071

JS 08/05/22 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Monday, 12/05/2008 10:01:30 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39190

Part Number: D350607043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D2537	Bushing
------	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing

37605

AS 08/05/22 (X)

13.0	D27283	Dart Logo Label - large
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3 Label

22553

AS 08/05/22 (X)

14.0	D2931	Bumper
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2931 Bumper

21139

AS 08/05/22 (X)

15.0	AN316A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A Bolt

M106815

AS 08/05/22 (X)

16.0	AN413A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-13A Bolt

M107534

AS 08/05/22 (X)

17.0	AN422A	Bolt
------	--------	------



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

7 AN4-22A Bolt

M104937

AS 08/05/22 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39190

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

M107939

AS 08/05/22 (v1)

19.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer

M107091

AS 08/05/22 (v1)

20.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

14 AN960JD416

Washer

M107321

AS 08/05/22 (v1)

21.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416L

Washer

M107008

AS 08/05/22 (v1)

22.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer

M107534

AS 08/05/22 (v1)

23.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer

M107715

AS 08/05/22 (v1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39190

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet

M18071

JS 08/05/22 (X)

25.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

M107644

JS 08/05/22 (X)

26.0

MS21042L4

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

9 MS21042L4 Nut (or -4)

M106051

JS 08/05/22 (X)

27.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5)

M107464

JS 08/05/22 (X)

28.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

Seal Support Gusset with Sikaflex -291

Batch: M107804

Exp Date: 2008/10

CB 08/05/26 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Monday, 12/05/2008 10:01:30 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39190

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 08/05/22 (X)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

31.0

D22301

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

38740

AS 08/05/22 (X)

32.0

D22303

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

37918

AS 08/05/22 (X)

33.0

D23241

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 *D2324-1

Strut Ass'y

36749

AS 08/05/22 (X)

34.0

D2732

Rubber Extrusion



Comment: Qty.: 2.0000 f(s)/Unit Total : 2.0000 f(s)

Rubber Extrusion

-8x D2732-030 (cut to 3")

Batch:

37632

AS 08/05/22 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:01:30 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39190

Part Number: D350607043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	AN412A	Bolt
------	--------	------



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

M105143

JS 08/05/22 (X)

36.0	AN413A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-13A

Bolt

M67534

JS 08/05/22 (X)

37.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch:

M107321

JS 08/05/22 (X)

38.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

M107321

JS 08/05/22 (X)

39.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

M106051

JS 08/05/22 (X)

40.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/05/22 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:01:30 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39190

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-043

Location: _____

Rev. F

KS 08/05/27 (XU)

42.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/28 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-607-041/-043 (LH installation)	88 lb 39.9 kg	- 48 in - 1.22 m	- 4224 in-lb - 48.7 m-kG	135 in 3.43 m	-11880 in-lb -136.9 m-kG
D350-607-041/-043 (RH installation)	88 lb 39.9 kg	+ 48 in + 1.22 m	+ 4224 in-lb + 48.7 m-kG	135 in 3.43 m	11880 in-lb 136.9 m-kG

5. PARTS LIST

Qty -041	Qty -043	Part Number	Description
X		D350-607-041	HELI-UTILITY-BASKET
	X	D350-607-043	HELI-UTILITY-BASKET
2	5	D2022-101	SPACER
1	1	D2221	BASKET BASE ASSEMBLY
4	4	D2230-1	LUG
4	4	D2230-3	CLAMP
1	1	D2258-200	LABEL
1	1	D2324	STRUT
1	1	D2332-041	PROP ASSEMBLY
1		D2512	BASKET LID ASSEMBLY
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
4	4	D2856-400-720	ABRASION STRIP
2	2	D2931	BUMPER
	1	D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	1	D2989-043	BASKET LID ASSEMBLY (INSIDE)
2	2	AN3-16A	BOLT
2		AN4-7A	BOLT
5	5	AN4-12A	BOLT
8	10	AN4-13A	BOLT
1	7	AN4-22A	BOLT
1		AN4-24A	BOLT
4	4	AN5-17A	BOLT
2	2	MS20600AD4W3	RIVET (OR CR9163-4-3)
28	40	AN960JD416	WASHER
2	2	AN960JD416L	WASHER
4	4	AN960JD516	WASHER
2	2	AN960JD8	WASHER
4	4	AN970-4	WASHER
2	2	MS21042L3	NUT (OR MS21042-3)
17	22	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

SHOP COPY
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 39190

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Revision: F
Date: 03.01.17



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9318	REV. A SHEET 1 OF 1
DATE 06.01.06		TITLE WASHER ADDITION	SCALE NTS
A	06.01.06	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F

REF. CANADIAN STC: SH94-14 ISSUE 4

REF. FAA STC: SR00213NY

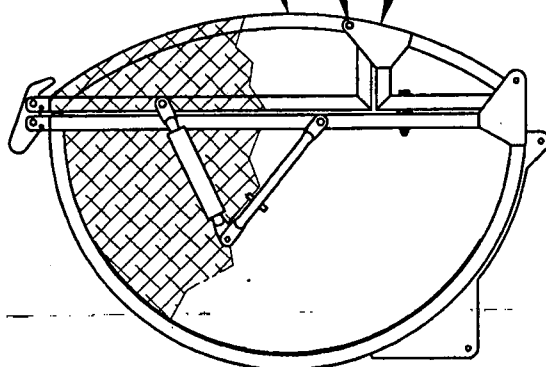
To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047 Heli-Utility-Basket**.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:

AN4-13A BOLT (1)
AN960JD416 WASHER (1)
HINGE PLATE (REF)
NAS1515H4 WASHER (1)
BASKET FRAME (REF)
AN960JD416 WASHER (1)
MS21042L4 NUT (1)
(2 PLACES)

BASKET FRAME (REF)

HINGE PLATE (REF)



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WORK ORDER
NO. 39190

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE #02)

DATE: 06.01.06
CERT. NO.: SH94-14
ISSUE NO.: 4

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Date: Monday, 12/05/2008 10:01:37 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASSEMBLY
Job Number : 39190A	
Estimate Number : 10206	
P.O. Number :	Part Number : D2989041 <i>pt 08.05.12</i>
This Issue : 12/05/2008 S.O. No. :	Drawing Number : D2989 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 39132A	Material :
Written By :	Due Date : 15/06/2008 Qty: 1 Um: Each
Checked & Approved By : <i>JLD 08.05.12</i>	
Comment : Est Rev: Removed D2989-043 05-11-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty.(1) D3166-3 Batch: *B38780* ✓*SAD 08/05/12 ①*

2.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2581 Mounting Brackets *B3243**PD 08-05-21*

3.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2327-3 Bushing *B37851**PD 08-05-21*

4.0	D2506	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2506 Label Plate *B37446* ✓*FC 08 05 21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:01:37 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 39190A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total: 15.0000 sf(s)

Pick:

Qty Part number Description Batch
15sf M304EX0.75-16F Expanded Metal

M107856 SAV 08/05/20 (D)

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total: 31.7709 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: M107857

SAV 08/05/20 (D)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

SAV 08/05/20 (D)

2-Drill holes in tubing as D2989-041 per Dwg D2989 FC

3-Deburr and remove all markings on material FC

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required FC

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

FC 08 05 22

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ID 08-05-23 (D)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP.

ID 08-05-23 (D)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

M- 08/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:01:37 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 39190A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: m107603

Wing Walk: m107892

START TIME:

10:00 am

OVEN TEMPERATURE:

400 F

FINISH TIME:

10:30 am

FL 08/05/26 (1)
2nd coat Start Time: 10:45
oven Temp: 400 F
Finish Time: 11:15

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

EB 08/05/26 @

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/28

Job Completion



MF 08-05-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05.08.19 *[Signature]*

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

UNDER REVIEW

08.05.05 PH
TUBING TO BE
CHANGED TO 0.065
WALL
PH
08.05.12

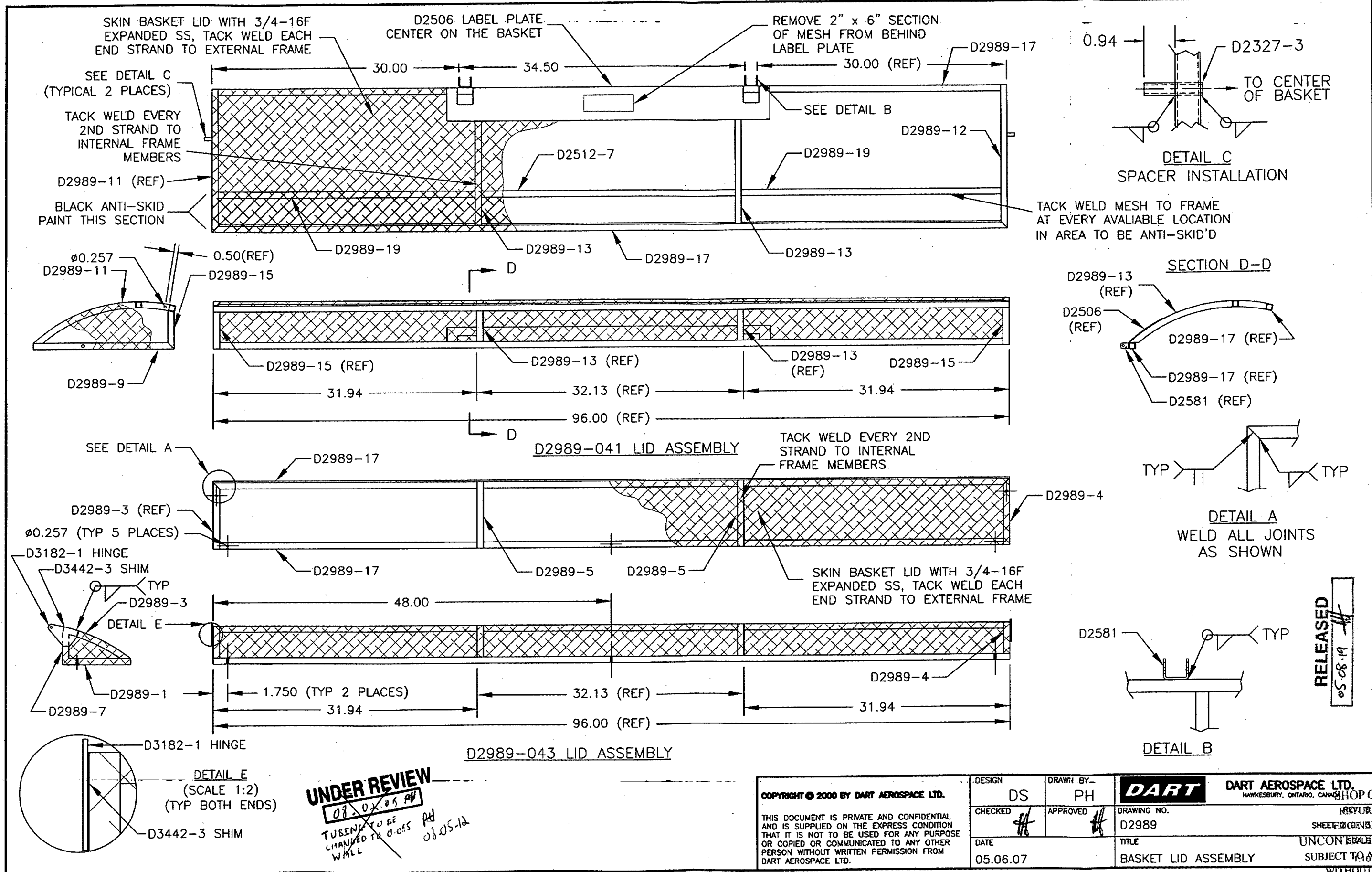
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WITHOUT NOTICE
WORK ORDER
NO. 39190A

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
- BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

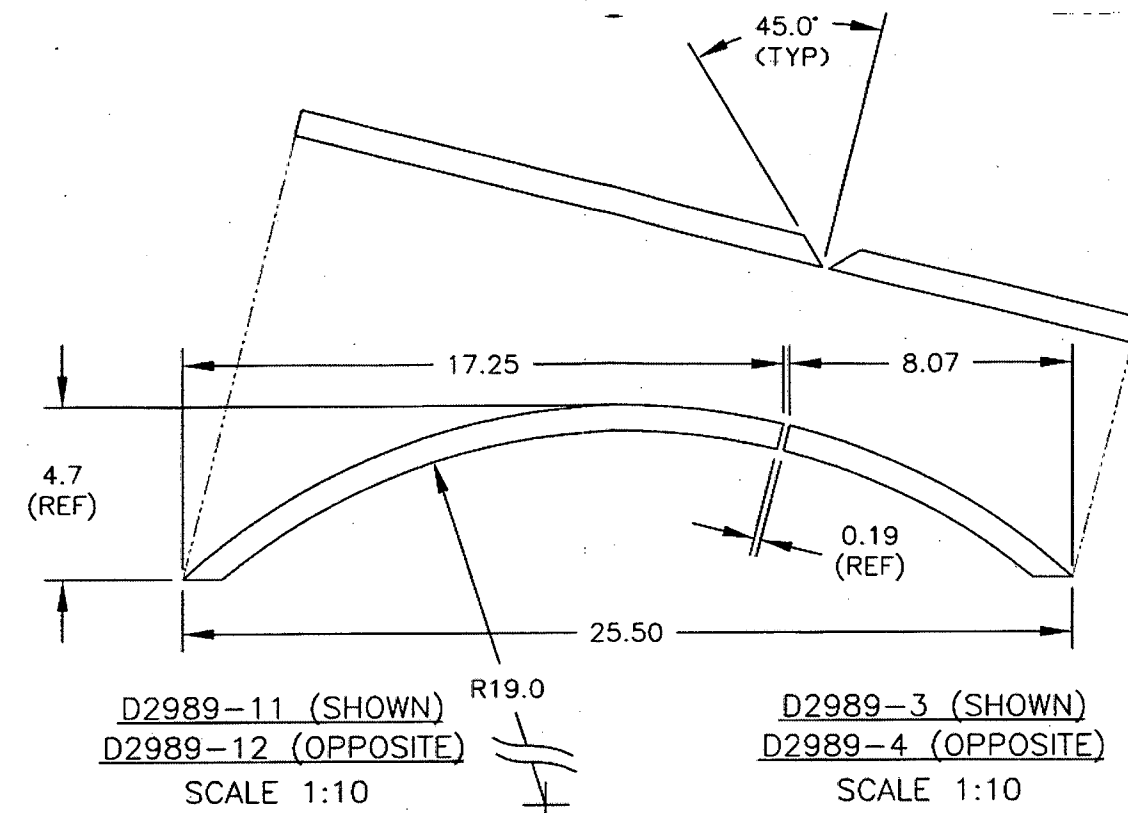
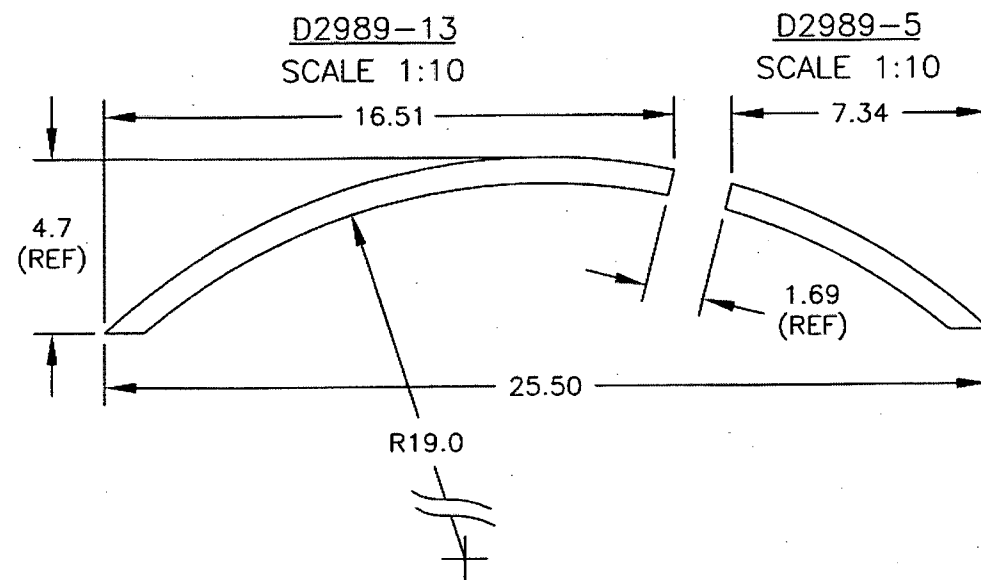
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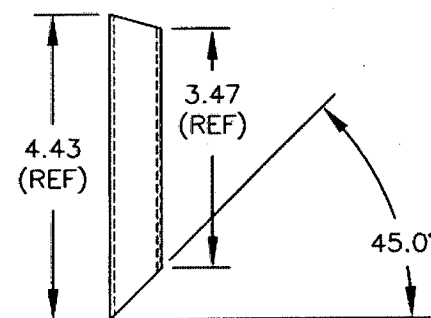
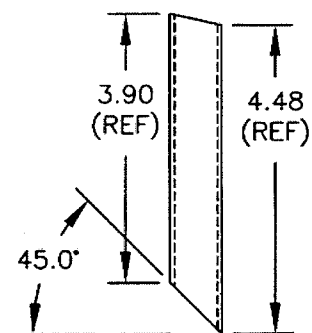
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CHECKED		PH	APPROVED	DRAWING NO.	RETURN TO
DATE		05.06.07		D2989	SHEET 2 OF 2
				TITLE	UNCONTROLLED COPY
				BASKET LID ASSEMBLY	SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 3919019



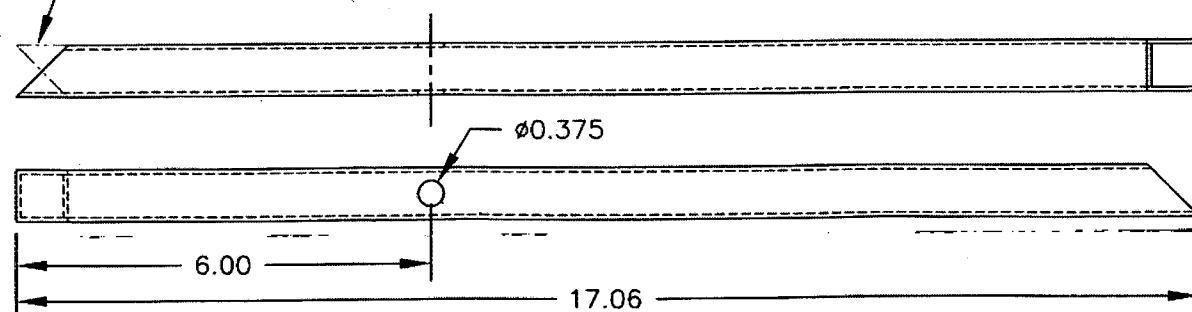
D2989-15
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

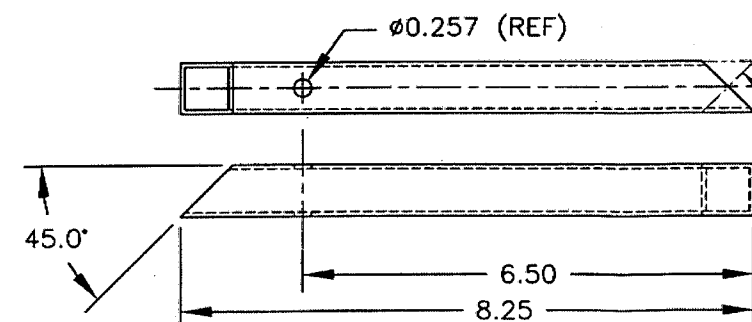


D2989-9 (SHOWN)
D2989-10 (SIMILAR)
SCALE 2:5

THIS END OPPOSITE FOR D2989-10



D2989-1 (SHOWN)
D2989-2 (OPPOSITE)
SCALE 2:5



UNDER REVIEW
08.02.05 PH
TUBING TO BE
CHANGED TO 0.065
WALL # 08.05.12

THIS END OPPOSITE
FOR D2989-2

RELEASED

05.08.19

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WORK ORDER
NO. 39190A

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DESIGN DS	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D2989	REV. B SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY	SCALE 1:10	

Date: Monday, 12/05/2008 10:01:47 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET LID ASSEMBLY
Job Number :	39190B		
Estimate Number :	10207		
P.O. Number :		Part Number :	D2989043 <i>pt 08.05.12</i>
This Issue :	12/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2989 UNDER REVIEW
First Issue :	1/1	Project Number :	N/A
Previous Run :	39132B	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<i>JLM 08.05.12</i>	Due Date :	15/06/2008
Comment :	Est Rev:1 Removed D2989-041 05-11-03 JLM	Qty:	1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31821	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number	Description	Batch
2 D3182-1	Hinge	<i>336483</i>

✓

FC 08 05 21

2.0	D34423	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number	Description	Batch
2 D3442-3	Shim	<i>D37160</i>

✓

FC 05 08 21

3.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)

Pick:

Qty Part number	Description	Batch
8sf M304EX0.75-16F Expanded Metal		<i>M107956</i>

✓

SAD 08/05/20 (1)

4.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SS tubing.

Batch: *M107967*

0.065 pt 08.05.12

SAD - 08/05/20 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:01:47 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 39190B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989
Note: D2989-3/-4 On -041 Bom

SAD

08/05/20

①

2-Drill holes in tubing as D2989-043 per Dwg D2989

FC

3-Deburr and remove all markings on material

FC

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

FC 08/05/22

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD

08-05-23

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD

08-05-23

8.0

POWDER COATING

POWDER COATING



M107925



①

Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:00am 2nd coat
400°F
10:30am

Start Time: 10:45
Oven Temp: 400°F
Finish Time 11:15

M/L 08/05/23

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

08/05/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:01:47 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 39190B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/28 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05-08-19 *[Signature]*

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x ~~0.060~~ ^{0.065 RH 08.05.12} WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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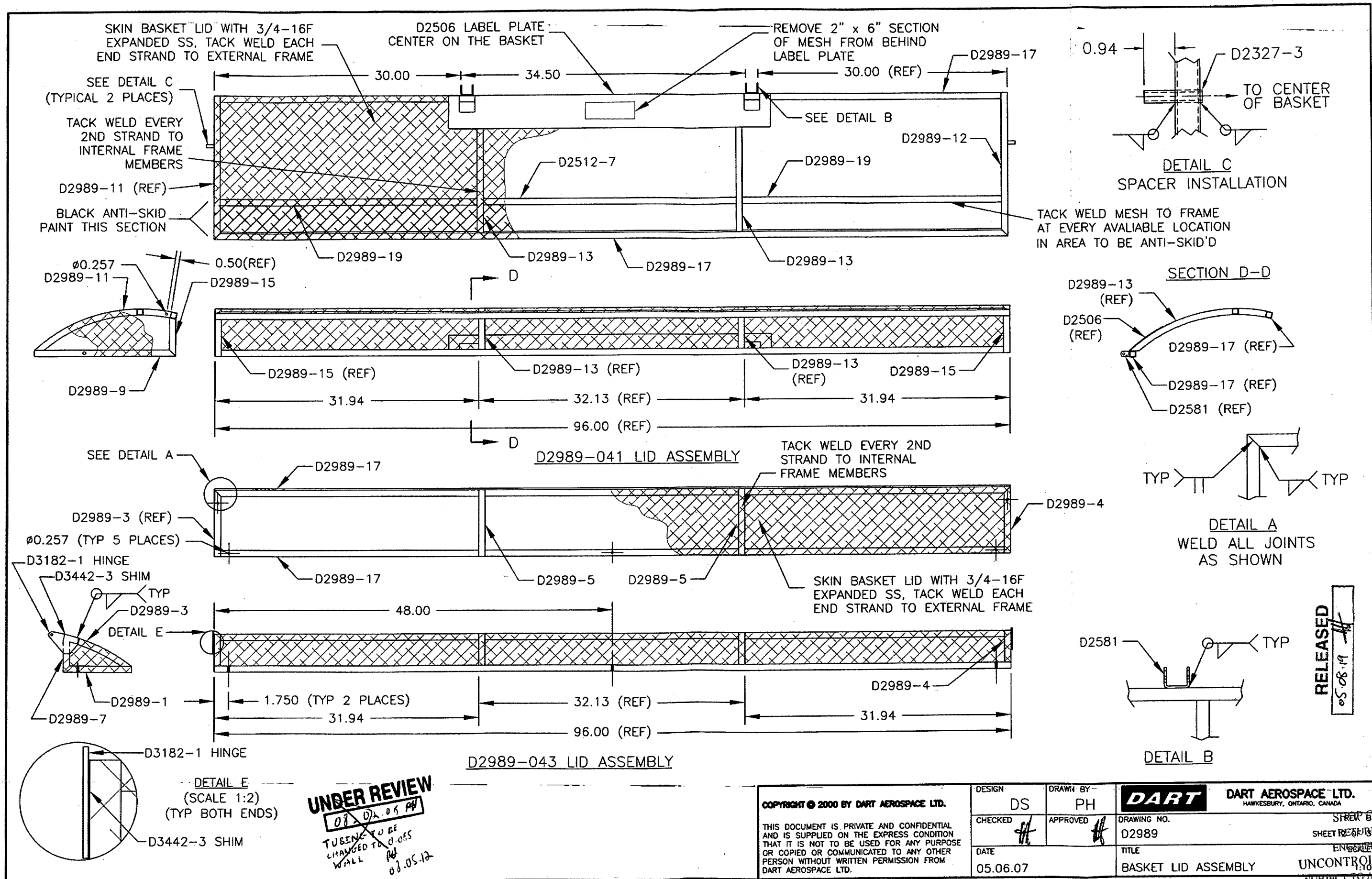
08-05-12
TUBING TO BE
CHANGED TO 0.065
WALL RH
08.05.12

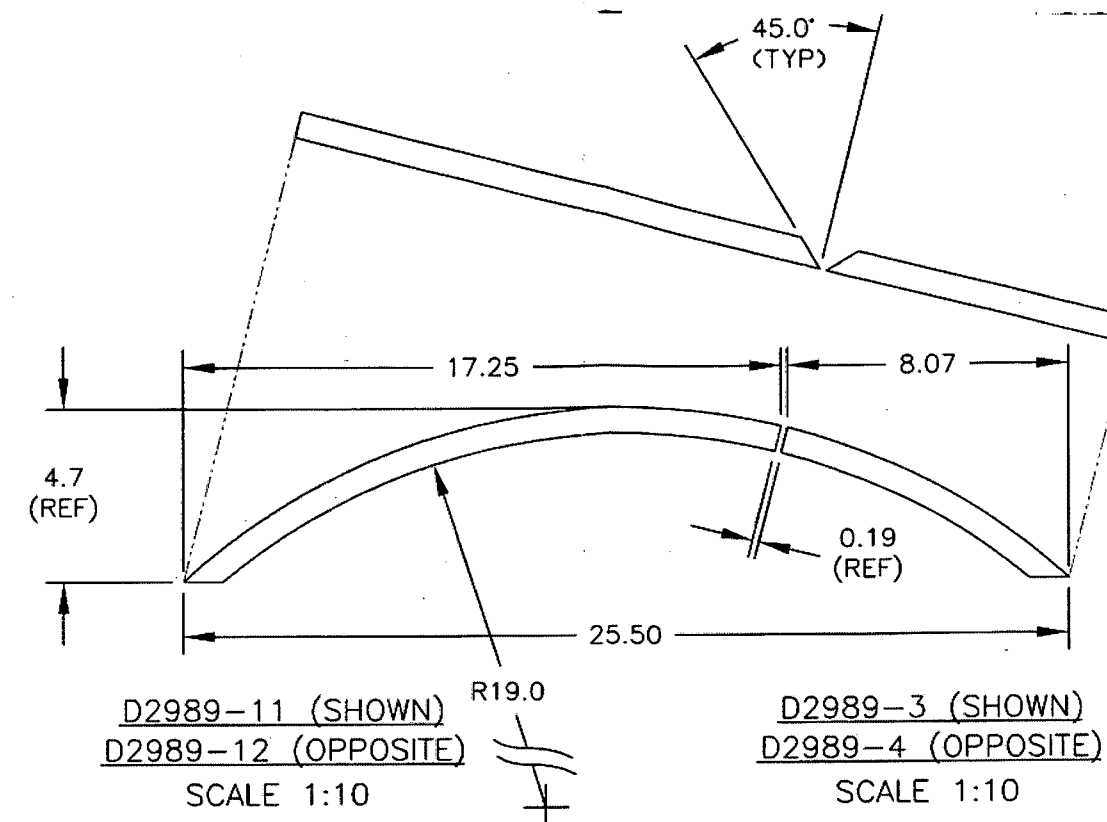
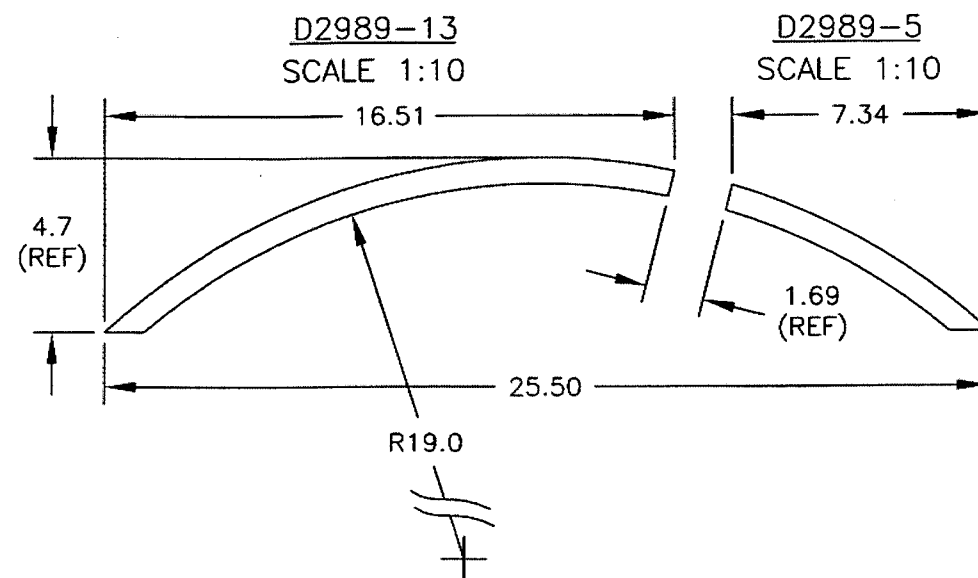
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WORK ORDER

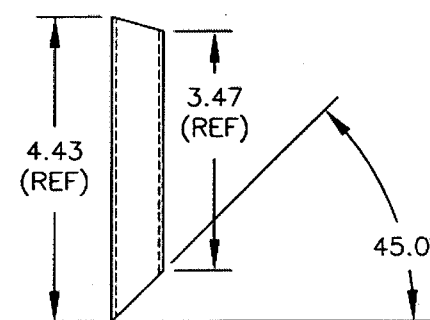
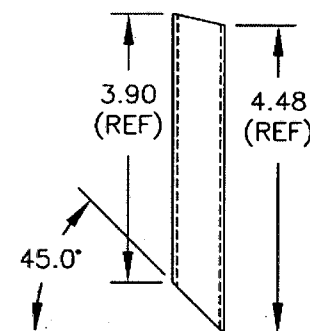
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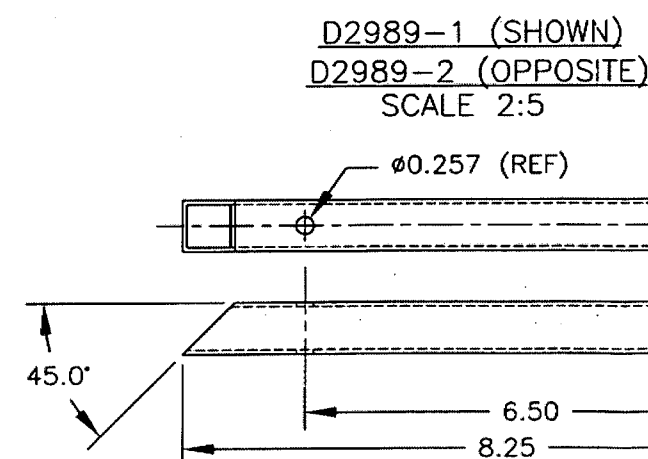
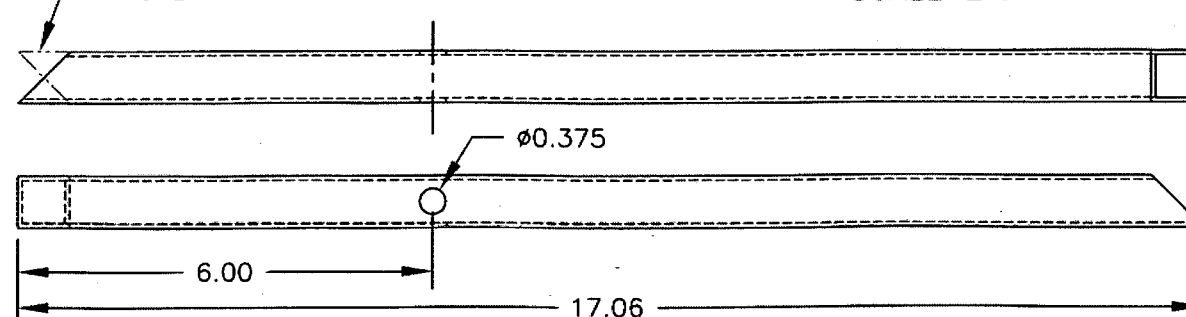
D2989-15
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)
D2989-10 (SIMILAR)
SCALE 2:5

THIS END OPPOSITE FOR D2989-10



UNDER REVIEW
08-02/06 PH
TUBING TO BE
CHANGED TO Ø0.065
WALL
08 05.12

THIS END OPPOSITE
FOR D2989-2

RELEASED

05-08-19

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DESIGN DS	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D2989	REV. B SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY	SCALE 1:10	

Date: Monday, 12/05/2008 10:01:56 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET BASE ASSEMBLY (350)
Job Number :	39190C		
Estimate Number :	10189		
P.O. Number :		Part Number :	D2221 <i>pt 08.05.12</i>
This Issue :	12/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2221 U/R , D2235
First Issue :	/ /	Project Number :	N/A
Previous Run :	39132C	Drawing Revision :	F/B1
Written By :		Material :	
Checked & Approved By :	<i>JUL 08.05.12</i>	Due Date :	15/06/2008
Comment :	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3166-1 RIB

D39048

✓

FC 08 05 21

2.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 Hinge bracket

D36846

✓

FC 08 05 21

3.0	D2325	Support Gusset (350 Basket)
-----	-------	-----------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2325

Support Gusset

D37449

✓

FC 08 05 21

4.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2327-3

Bushing

D37851

✓

FC 08 05 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:01:56 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 39190C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket

037248

FC 08 05 21

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim

037615

FC 08 05 21

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch

39.69 sf M304EX0.75-16F Expanded Metal

M107856

SAD 08/05/20

Ⓟ

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M107967

SAD

08/05/20

Ⓟ

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

GAP

08/05/20

Ⓟ

2-Drill hole in D2221-3 as per Dwg D2221

FC

3-Deburr

FC

4-Remove all markings on material before welding

FC

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

FC

08 05 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:01:56 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services-

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 39190C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-05-23

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 08-05-23

12.0

POWDER COATING

POWDER COATING



MI 107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
400°F
11:00

2nd coat
start time: 11:15
oven Temp: 400°F
Finish Time: 12:00

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CB 08/05/26 @

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/28 JF

Job Completion



MF 08-05-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

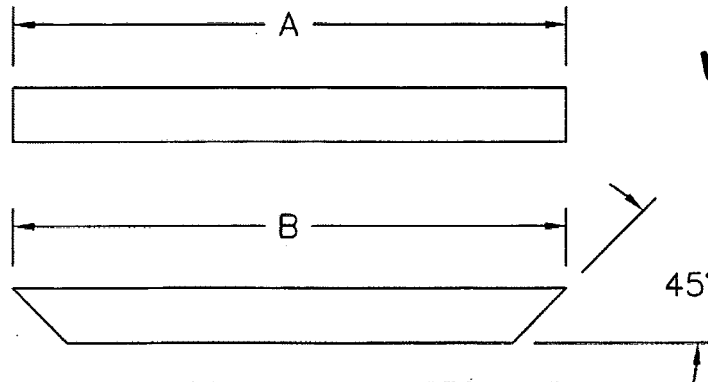
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
C	95.11.21	SEPARATE BASKET AND LID	
D	96.06.21	CHANGE LATCH	
E	01.04.19	CHANGE HINGE	
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED05.08.19 *H***PARTS LIST FOR D2221 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM

**UNDER REVIEW**08.02.05 *PH*
TUBING NOTE
CHANGED TO 0.065
W/ *W*
PH
08.05.12D2221-1/-3/-5/-7

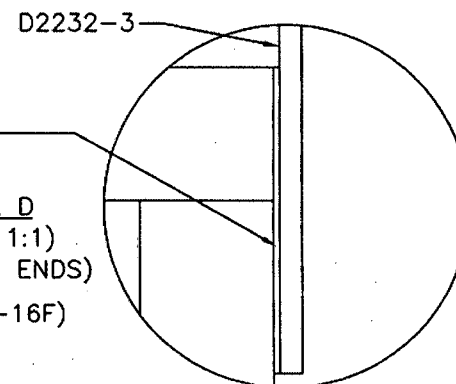
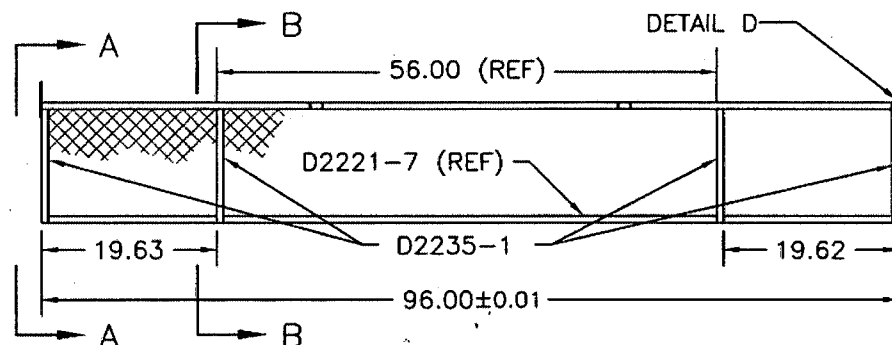
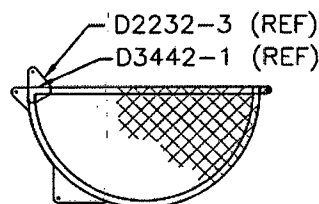
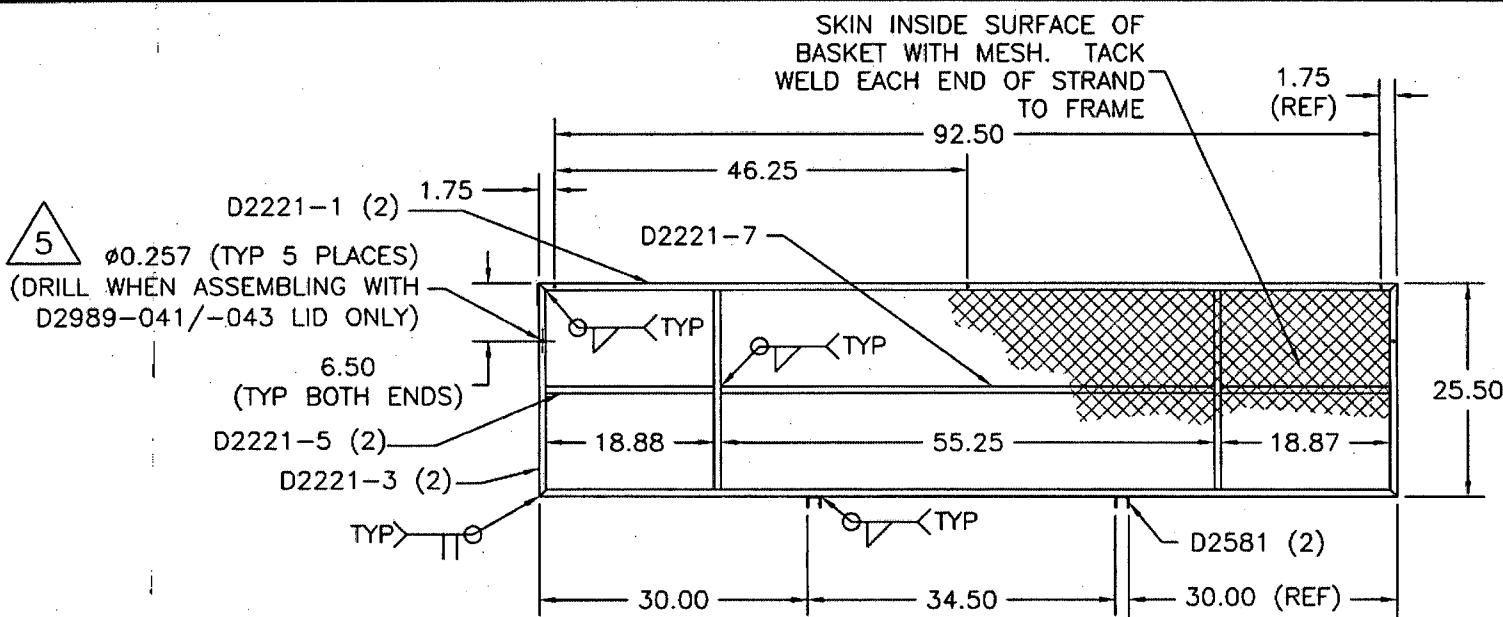
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060) *PH 08.05.12*
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL $\phi 0.257$ HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2221	SHEET 2 OF 3
DATE	05.06.07	TITLE	BASKET BASE ASSEMBLY (350)	SCALE	1:20



UNDER REVIEW

08.05.05 PH

TUBING TO BE CHANGED TO 0.065 WALL

08.05.12

RELEASED

05.08.19

NO. 391908

WORK ORDER

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D2325 (REF)

D2221 BASKET BASE ASSEMBLY

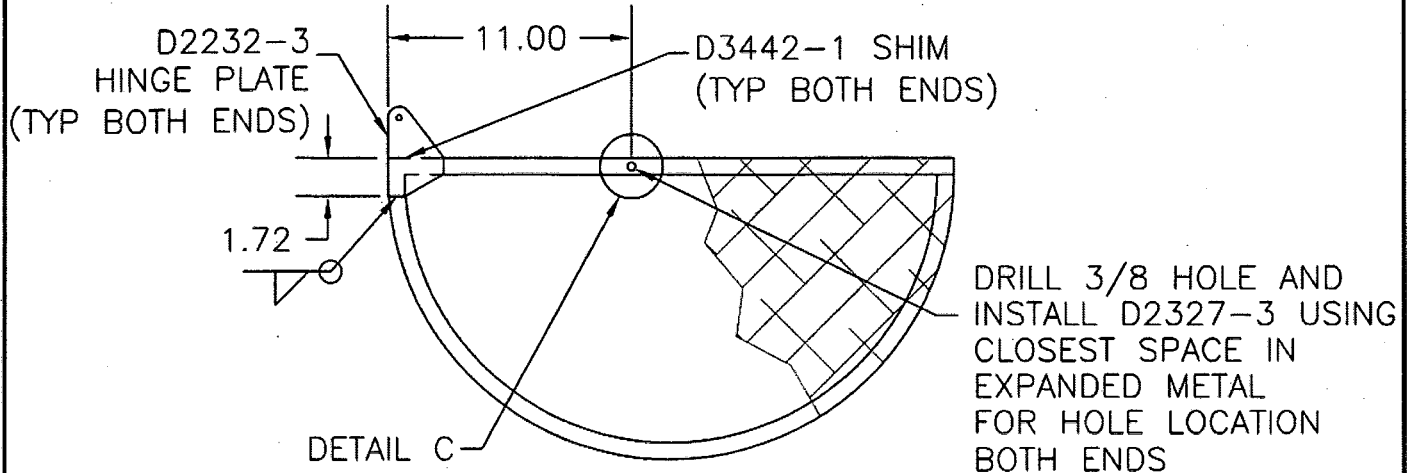
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

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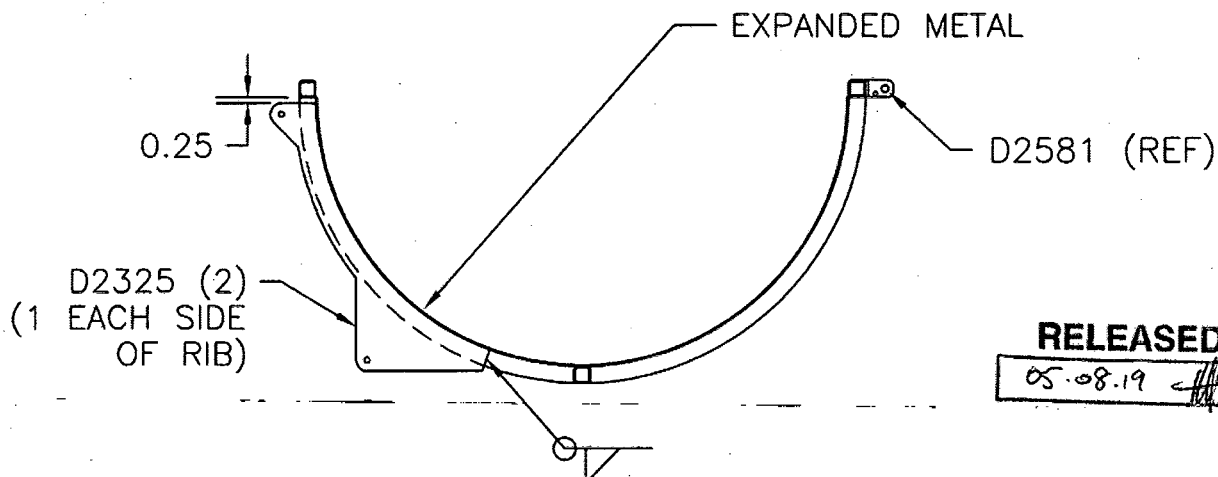
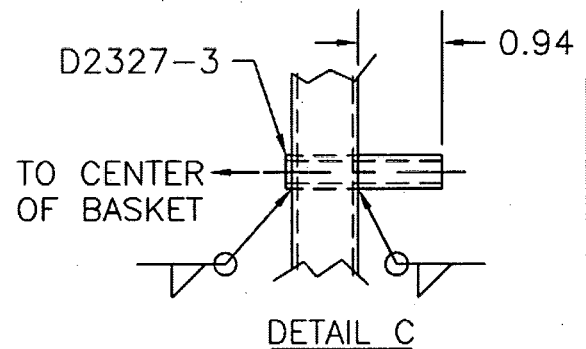
DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)		SCALE 1:8



SECTION A-A SAME BOTH END RIBS

UNDER REVIEW
08.02.08 PH

TUBING TO BE
CHANGED TO 0.065
WALL
PH
03.05.12



SECTION B-B SAME BOTH CENTER RIBS

RELEASED

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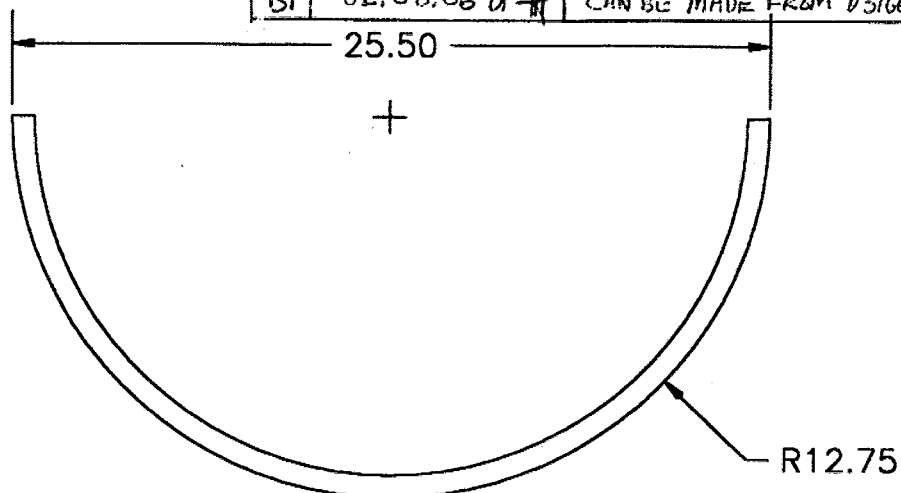
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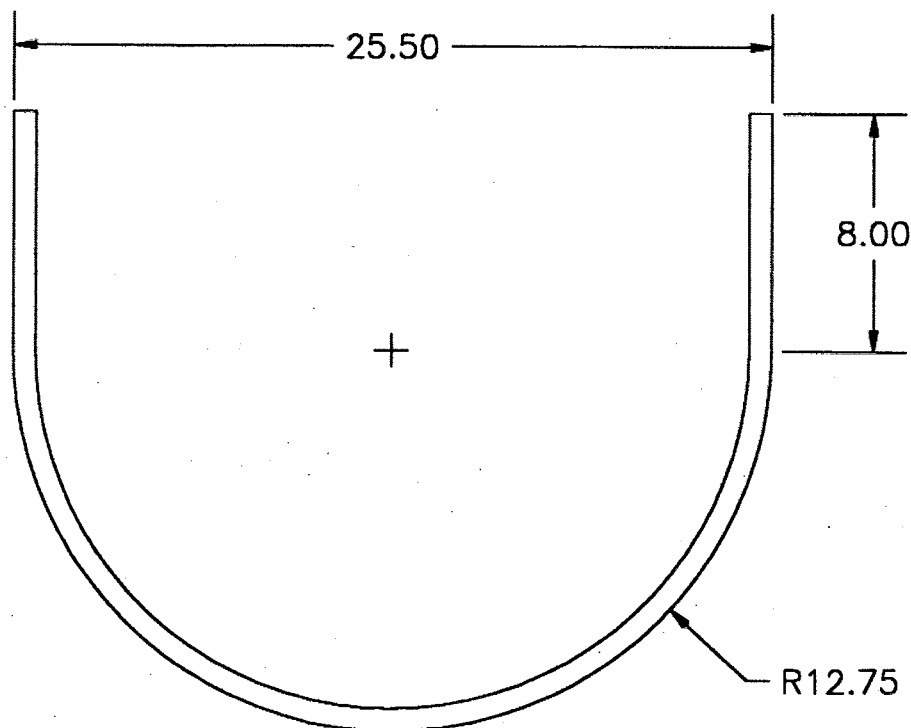


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2235	SHEET 1 OF 1
DATE 94:12:16	TITLE BASKET RIBS		SCALE
BI	02.08.06 <i>UP</i>	CAN BE MADE FROM D3166-1	


RELEASED
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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